

Work Order ID 65962 - ^{SPLIT}

Friday, January 28, 2011 11:39:51 AM



Page 1

Item ID: D4148-1

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug Plate, Fwd

Stop



Start Date: 1/28/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 1/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: mf

Date: 11-01-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4148	C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D4148

Prog Rev: E

Dwg Rev: C

Deburr as required

B11-1-28

(2)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-1-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65962

Friday, January 28, 2011 11:39:51 AM



Page 2

Item ID: D4148-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Plate, Fwd

Start Date: 1/28/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 1/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

Sub 1/28



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

0.00

Packaging

w/o
65961

EB 11/01/28 (2)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/31

MF
11-01-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, January 28, 2011 11:39:45 AM

Page 1

Work Order ID: 65962



Parent Item: D4148-1



Parent Item Name: Crosstube Lug Plate, Fwd

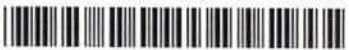
Start Date: 1/28/2011

Required Date: 1/28/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.10.29 as per revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	62.7000	0.3607	3.796842			



1811-1-28

Location

Loc Qty

Loc Code

MAT

62.7

116623

62.7

116623

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 65967
Description: Fwd Crosstube Lug Plate		Part Number: D4148-1
Inspection Dwg: D4148	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.130	X		U B2	
Ø0.191	+0.005/-0.001	.192	X		U	
Ø0.38	+0.006/-0.001	.379	X		U	
Ø0.257	+0.006/-0.001	.258	X		U	
Ø0.50	+0.008/-0.001	.499	X		U	
0.94	+/-0.030	.940	X		U	
4.47	+/-0.030	4.469	X		U	
0.750	+/-0.010	.759	X		U	
8.47	+/-0.030	8.465	X		U	
8.096	+/-0.010	8.100	X		PROWS-02	
5.43	+/-0.030	5.420	X		U	
5.197	+/-0.010	5.200	X		U	
4.733	+/-0.010	4.731	X		U	
0.310	+/-0.010	.303	X		U	
0.750	+/-0.010	.744	X		U	
0.375	+/-0.010	.382	X		U	
1.84	+/-0.030	1.836	X		U	
0.92	+/-0.030	.910	X		U	
3.000	+/-0.010	2.997	X		U	
0.750	+/-0.010	.743	X		U	
0.625	+/-0.010	.625	X		U	
1.982	+/-0.010	1.980	X		U	
0.991	+/-0.010	.988	X		U	
0.77	+/-0.030	.768	X		U	
1.54	+/-0.030	1.543	X		U	
2.47	+/-0.030	2.468	X		U	
0.82	+/-0.030	.820	X		U	
3.57	+/-0.030	3.575	X		U	
1.23	+/-0.030	1.232	X		U	
0.73	+/-0.030	.735	X		U	
0.125	+/-0.010	.116	X		U	

Measured by: IB	Audited by: S	Preliminary Approval:
Date: 11-1-28	Date: 11/6/28	Date:

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	10.10.08	Dwg Rev updated	KJ	
C	10.11.05	Dimensions updated per Dwg Rev C	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries